

Split - 2

Work Order ID 87617-3

87617

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July-23-12 2:39:42 PM

Item ID: D2652

Revision ID:

Item Name: Bushing

Start Date: 7/13/12

Required Date: 8/10/12

Reference:

Start Qty: 100.00

Req'd Qty: 100.00

100

100

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan:

MLT

Date:

12/07/24

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2652	Rev A

100

100

Hardinge

Hardinge CNC Lathe Small

Hardinge CNC LATHE SMALL

Memo

1-TURN AS PER FOLIO FA252 & DWG D2652FOLIO
REV: *n/A* DWG REV: *A* 2-DEBURR AS REQUIRED

0.00

0.00

12/08/10

75

0

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

12/08/10

75

0

120

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

12/08/12

75

0

Work Order ID 87617

87617

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July-23-12 2:39:42 PM

Item ID: D2652 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bushing
 Start Date: 7/13/12 Start Qty: 100.00 ***100*** Cust Item ID:
 Required Date: 8/10/12 Req'd Qty: 100.00 ***100*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	Identify as per dwg & Stock Location: <u>14</u>	0.00							
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130

Packaging

Memo

0.00

Packaging

140	QC21- Final Inspection - Work Order Release	0.00							
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140

QC

Memo

0.00

Quality Control

MLJ 12/08/14

MLJ 12/08/14

Picklist Print

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July-23-12 2:39:41 PM

Work Order ID: 87617
Parent Item: D2652
Parent Item Name: Bushing

Start Date: 7/13/12

Required Date: 8/10/12

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP Rev:B02.06.13Now machined in house.NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.500		Purchased	No			100	f	242.7780	0.055	5.78947	13.188	8/12/08/11	
303 Round Bar 0.500"													

Location	Loc Qty	Loc Code
MAT028	242.778	
117143	11.34	
118509	1.36	
119009	137.705	
119616	36.737	
121728	55.636	

6.855'
2.083'
4.250'

119009 → 4.166'

121728 → 4.250'

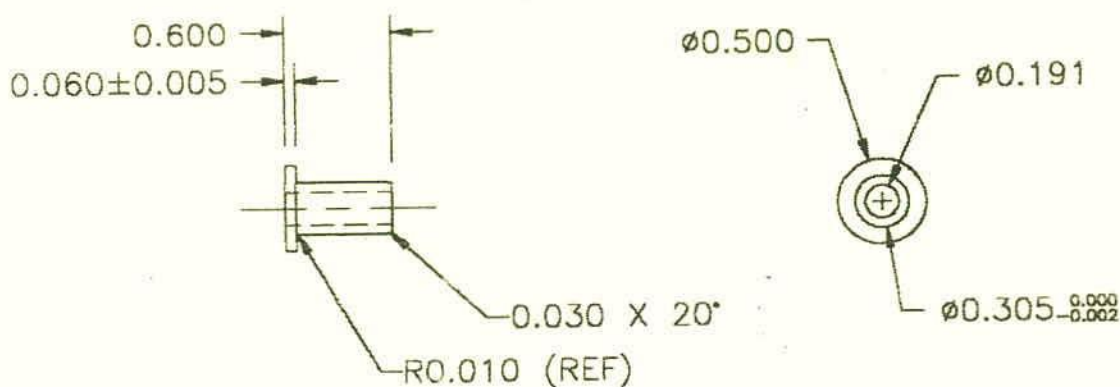
119.616 → 2.083

Material taken so far
including bars on
hydraulic tank.



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2652	REV. A SHEET 1 OF 1
DATE 97:03:25		TITLE BUSHING	SCALE 1:1

RELEASED
97/04/25 DS



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27617 MCT
12/07/24

MATERIAL: AISI 303 SS
NOTE: BREAK ALL SHARP CORNERS 0.010 MAX
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

